

Date: Tuesday, 19/05/2009 10:16:51 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUARD
Job Number	: 47985		
Estimate Number	: 13938		
P.O. Number	:	Part Number	: D39273
This Issue	: 19/05/2009 S.O. No. :	Drawing Number	: D3927 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	:	Material	:
Written By	:	Due Date	: 26/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-05-19</u>		
Comment	: Est Rev:A New Issue 09-05-15 JLM Verified By:EC		



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDLRINB2000X02000	Black Delrin Bar 2" x 2"
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Comment: Qty.: 1.6800 f(s)/Unit Total : 1.6800 f(s)

Black Delrin Bar 2" X 2"

BATCH: M111828

JTP 09/05/28 (1)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 19.250" long

JTP 09/05/28 (1)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA822 Rev: AA & Dwg D3927Rev: PREL

2-Deburr per dwg D3927

JTP 09/05/29

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK ENGINEERING APPROVAL
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Comment: SECOND CHECK

CP 09.06.01

Date: Tuesday, 19/05/2009 10:16:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUARD

Job Number: 47985

Part Number: D39273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



CP 09.08.27

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENG/HAI ONLY

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09/08/27 AUTH 4

RELEASED _____ DATE _____

NOT RECD - TO BE USED

FOR HAI ONLY

(PART SCRATCHED)
09/08/27

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-636-107

Job #: P00285

Date: 09.05.11

Product Name: Cable Guard Kit

Requested By: HS

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3927-1		Forward Cable Guard	09.03.31				
1	D3927-3		Aft Cable Guard	09.03.31				
2	D3928-1		Bracket	09.04.01				

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

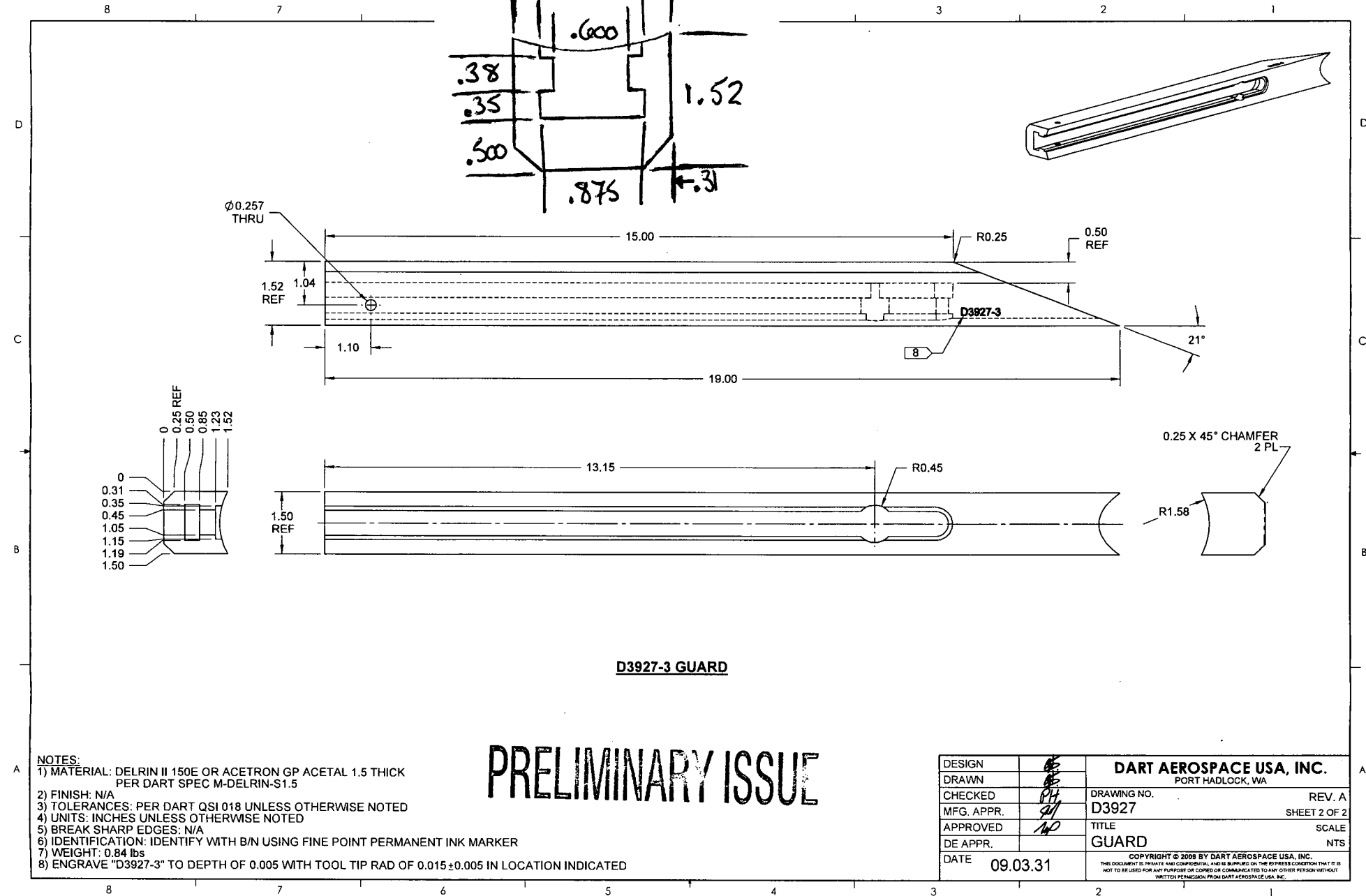
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.257	+0.006/-0.001	0.258	✓			Thru
1.52	± 0.030	1.511	✓			REF
1.04	± 0.030	1.049	✓			
1.10	± 0.030	1.102	✓			
19.00	± 0.030					
21°	± 1/2°	21°	✓			
0.50	± 0.030	0.503	✓			REF
R0.250	± 0.030	0.250	✓			
15.00	± 0.030	15.00	✓			
13.15	± 0.030	13.15	✓			
R0.45	± 0.030	0.45	✓			
0.25 x 45°	± 0.030 / ± 1/2°	0.450	✓			2 PL
R1.58	± 0.030	1.58	✓			
0.31	± 0.030	0.305	✓			
0.35	± 0.030	0.352	✓			
0.45	± 0.030	0.452	✓			
1.05	± 0.030	1.048	✓			
1.15	± 0.030	1.148	✓			
1.19	± 0.030	1.196	✓			
1.50	± 0.030	1.498	✓			REF
0.50	± 0.030	0.50	✓			
0.85	± 0.030	0.85	✓			
1.23	± 0.030	1.23	✓			

Measured by: <i>DTJ</i>	Audited by: <i>UP</i>	Prototype Approval: <i>CP</i>
Date: 09/05/29	Date: 09/06/01	Date: 09/06/01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

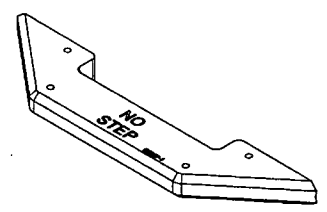
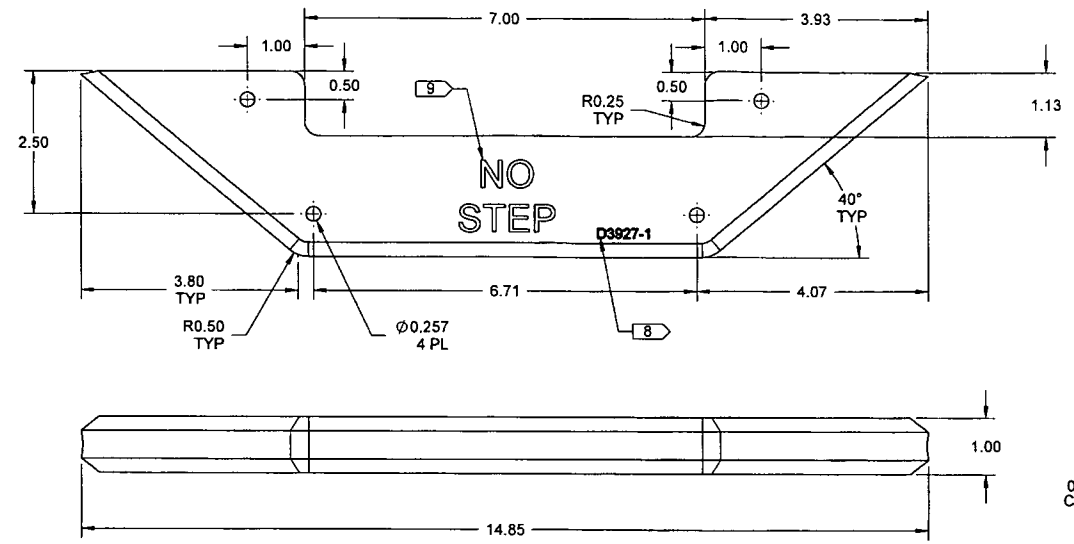
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B



D

C

B

D3927-1 GUARD

47985

RELEASED
09/03/31

NOTES:

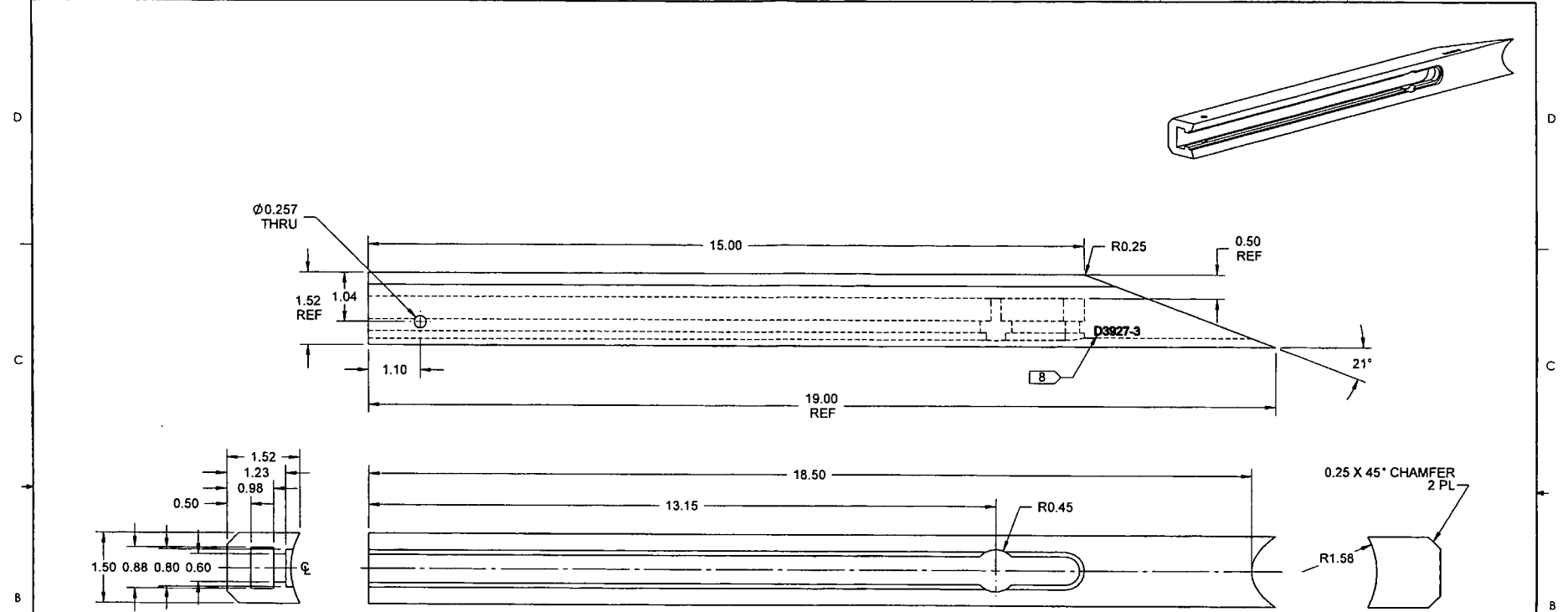
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED

A		NEW ISSUE		BY		DATE	
REV.		DESCRIPTION					
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA				REV. A	
DRAWN						SHEET 1 OF 2	
CHECKED		DRAWING NO.					
MFG. APPR.		D3927					
APPROVED		TITLE				SCALE	
DE APPR.		GUARD				NTS	
DATE		09.03.31					

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3927-3 GUARD

47984

RELEASED
01/17/12

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.5 THICK
PER DART SPEC M-DELIN-S1.5
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs
- 8) ENGRAVE "D3927-3" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 IN LOCATION INDICATED

DESIGN	47984	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3927	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GUARD	NTS
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8 7 6 5 4 3 2 1